

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011624**Date Inspected:** 22-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD

This QA inspector participated for longitudinal diaphragm dimensional survey along with ABF for below segments. Reports forwarded to team leader for further action

6AE-6BE

6BE-6CE (Only Bike path side)

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6BE-6CE)**FCAW Process:**

Welding of weld joint – 005 and 007 located on PCMK BK001-024, Bike path cantilever. Welder is identified as 053742. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Tc-U4b-F.

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FCAW Process:

Welding of weld joint – 006 located on PCMK BK001-024, Bike path cantilever. Welder is identified as 053742. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-Tc-U4b-F.

OBG # TRIAL ASSEMBLY YARD (7AE-7BE)

FCAW Process:

Welding of weld joint – 047 located on PCMK SP310-001, Side panel T-Rib weld. Welder is identified as 019006. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

FCAW Process:

Welding of weld joint – 031 located on PCMK SP461-001, Side panel T-Rib weld. Welder is identified as 019006. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

OBG # TRIAL ASSEMBLY YARD (6BE-6CE)

SMAW Process:

Welding of weld joint –004 located on PCMK OBE6C, Side panel transverse splice joining 6BE and 6CE. Welder is identified as 220066. ZPMC CWI is identified as Li Yang. Welding was been performed against critical welding repair report B-WR9906 and UT report B787-UT-10748. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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